

Work Order ID 78942

78942

Page 1

January-17-12 1:29:54 PM

Item ID: D3140-07

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door

Start Date: 17/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.C.5

Date: 12/01/17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3140	Rev F

100

0.00

100

Packaging

Memo

0.00

Packaging

Pick kit to ship to Delastek

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

N/A

1 12/09/21/10

C213/10/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78942

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Page 2

January-17-12 1:29:54 PM

Item ID: D3140-07 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door
 Start Date: 17/01/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>116439</u>								
	Purchase Part Number: D3140-07								
	Supplier: Delastek								
	Ship kit and make as per dwg								
	Conformity Certificate and Process sheet required								
130	Receive & Inspect for Damage & Mat'l Certs	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC6- Inspect dimensions to drawing	0.00							
140									
QC	Memo	0.00							
Quality Control	Ensure a copy of certification of conformity and process sheet from Delastek is attached.								

C2 12/02/17 ①

12/3/13 ①

DAS
16
9-88
13/15/17

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Accept

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Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door

Start Date: 17/01/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 31/01/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

13-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-17-12 1:29:58 PM

Page 1/2

Work Order ID: 78942

78942

Parent Item: D3140-07

D3140-07

Parent Item Name: Door

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.17 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3140-09 *D3140-09* Doubler Assembly		Manufactured	No			100	Each	5.0000	1	1	✓		
**													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
st151 5													
53767 5													
53767													
D3140-91 *D3140-91* Doubler		Manufactured	No			100	Each	4.0000	1	1	✓		
**													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
CA 4													
52203 4													
52203													
D3140-99 *D3140-99* Doubler		Manufactured	No			100	Each	5.0000	1	1	✓		
**													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
CA 5													
36761 1													
52632 4													
52632													
D3140-101 *D3140-101* Doubler		Manufactured	No			100	Each	1.0000	2	2	✓		
**													
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
CA 1													
50296 1													
50296													

D3140-07P

78942

1x 78724 JB 12/09/21
1x 50296

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D3140-07

D3140-07

Parent Item Name: Door

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3140-103

Manufactured No

100 Each

3.0000

1

1

✓

D3140-103

Doubler

**

JB

Location

Loc Qty

Loc Code

CA

3

34377

3

34377

D3140-105

Manufactured No

100 Each

1.0000

1

1

✓

D3140-105

Doubler

**

66430 JB

Location

Loc Qty

Loc Code

CA

1

66430

1

D3140-301

Manufactured No

100 Each

0.0000

1

1

✓

D3140-301

Doubler

**

78717 JB 12/09/21

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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR SCALE NTS	
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

SHIP COPY

RETURNED

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO APPROVAL

WITNESS SIGNATURE

DATE & CHECKER

7.8942 H.C.J
12/01/17

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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DESIGN <i>#</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>Jh</i>	APPROVED <i>#</i>	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13 *#*

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1

F

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27042

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[illegible]

RELEASED

06.11.13 #

Technical drawing of Section B-B of a propeller, showing internal structure and dimensions. The drawing includes the following labels and dimensions:

- TAPER A/R AS SHOWN PER TOOL # B30-23000-57T (2 PLACES)**: Indicated by arrows pointing to the tapered sections of the propeller.
- 1.00 REF**: Two reference dimensions for the tapered sections.
- D3140-63 (REF)**: Dimension for the upper part of the propeller.
- D3140-61 (REF)**: Dimension for the upper part of the propeller.
- D3140-63 (REF)**: Dimension for the upper part of the propeller.
- E761/7781 2 FLY THRU OUT INNER SHELL**: Dimension for the inner shell.
- R0.50**: Radius dimension for the inner shell.
- D3140-57 (3 PLACES)**: Dimension for the lower part of the propeller.
- D3140-59 (REF)**: Dimension for the lower part of the propeller.
- SECTION B-B**: Section line label.
- ALL OUTER RADI PER TOOL # B30-23000-01T/-02T**: Dimension for the outer radii.
- E761/7781 3 PLY THRU OUT OUTER SHELL**: Dimension for the outer shell.
- FILL IN GAPS & BOND PADS MA560 FOAM (A/R)**: Dimension for the gaps and bond pads.

D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-08 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-08)
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

Three triangles are shown, labeled 1, 2, and 3 from left to right. Each triangle has a horizontal base and two slanted sides meeting at a vertex above the base. The numbers 1, 2, and 3 are centered inside each triangle respectively.

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DESIGN

DRAWN BY	C.B.
----------	------

DART

DART AEROSPACE LTD.
HAMMERSLEY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

REV. F

DATE _____

1	TITLE	2	3	4	5	6	7	8	9	10	11	12

SCALE

06.10.06

DOOR

NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

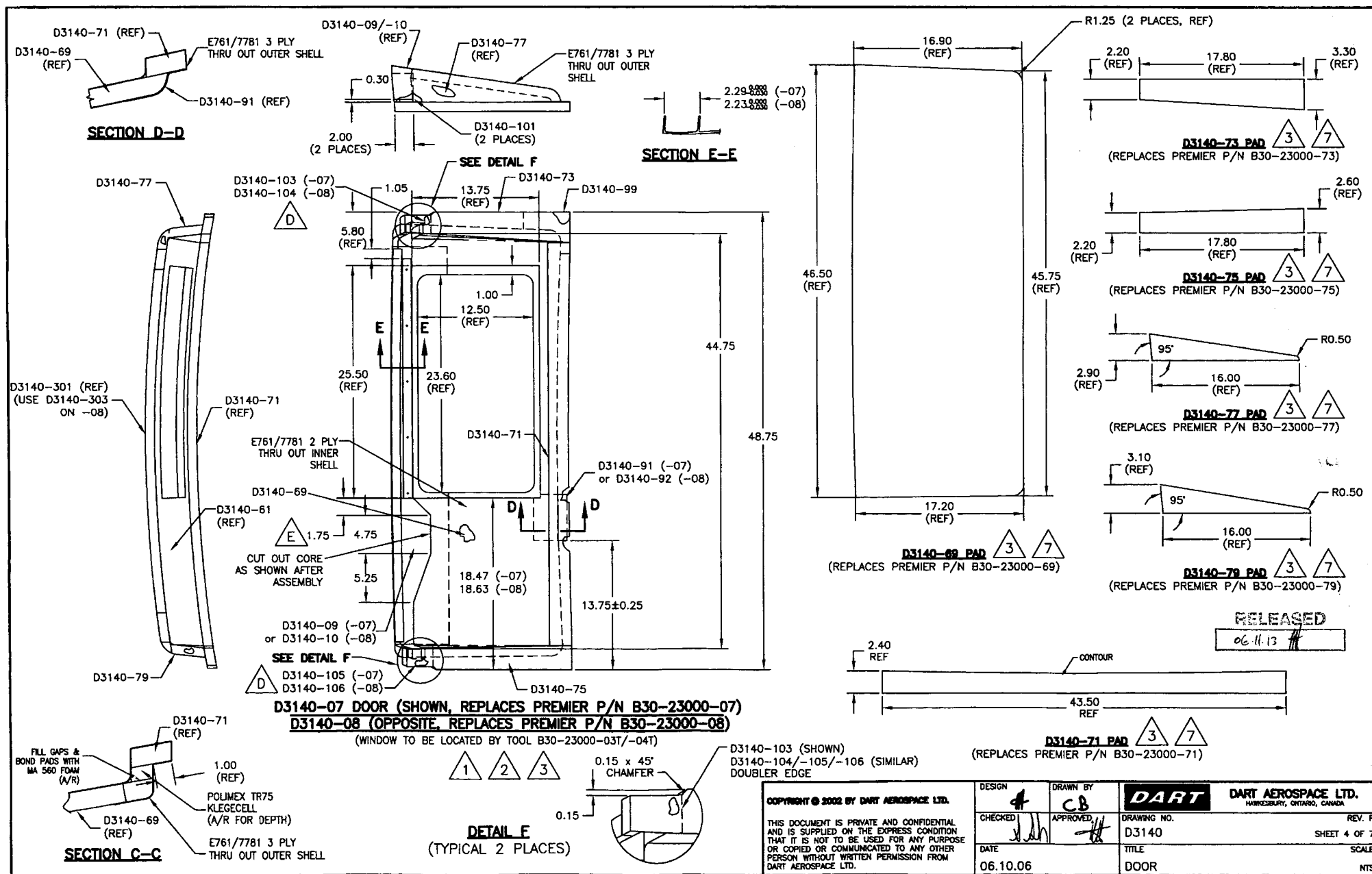
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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. F
DATE		D3140	SHEET 4 OF 7
06.10.06		TITLE	SCALE
		DOOR	NTS

W/O:		WORK ORDER CHANGES					
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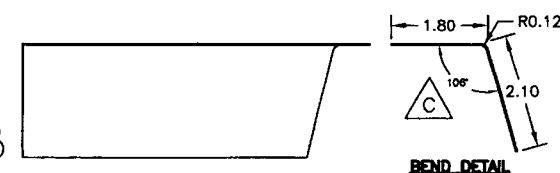
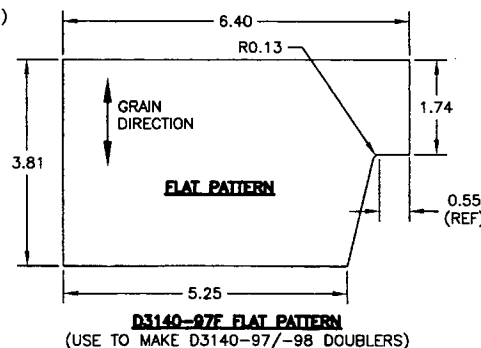
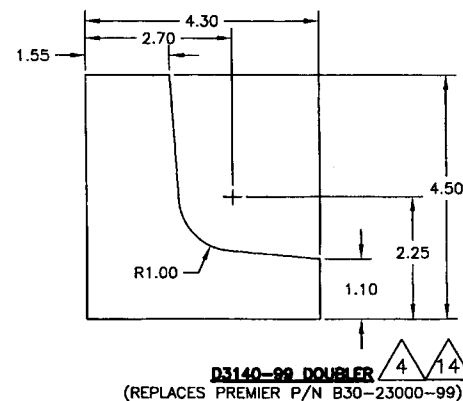
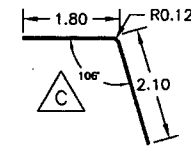
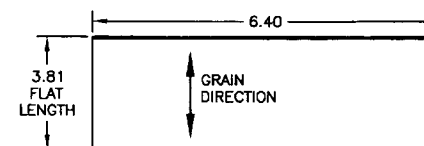
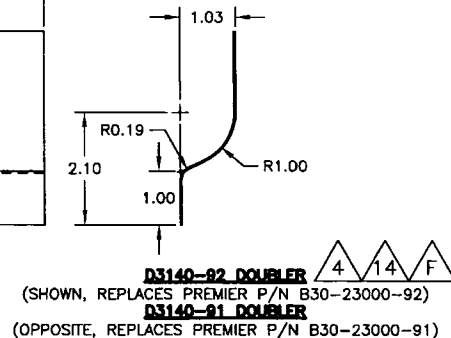
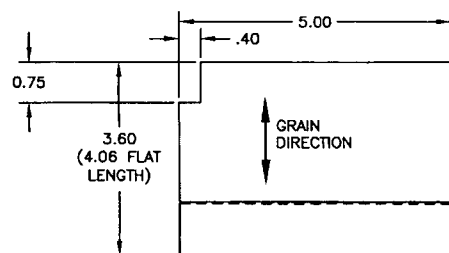
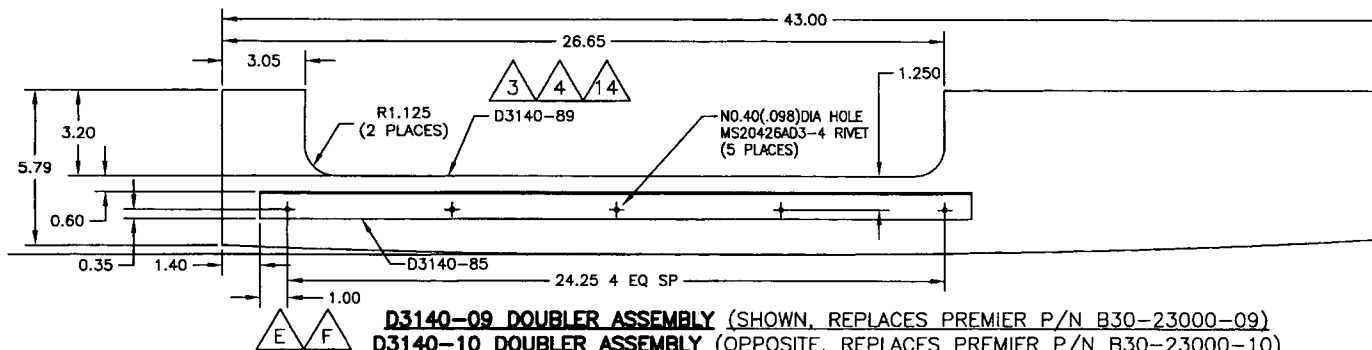
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RELEASED
 06.11.13

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		DATE 06.10.06		TITLE DOOR	SCALE NTS	

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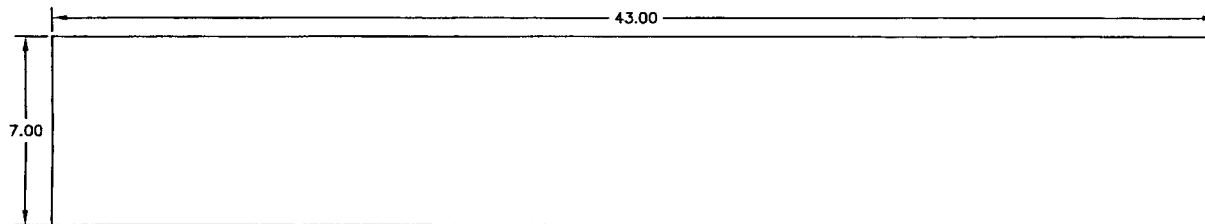
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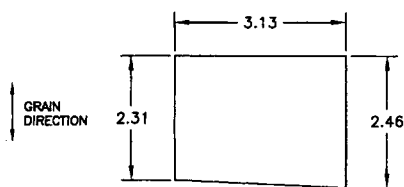
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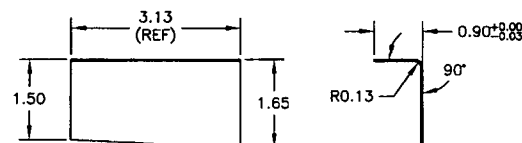
78942



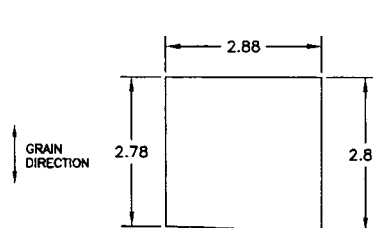
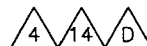
D3140-87 DOUBLER
(REPLACES PREMIER P/N 830-23000-87)



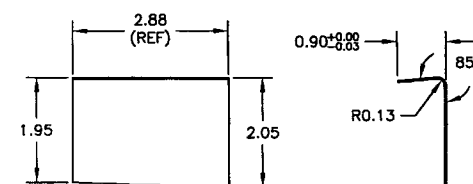
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)



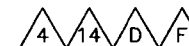
D3140-105 DOUBLER
D3140-106 OPPOSITE



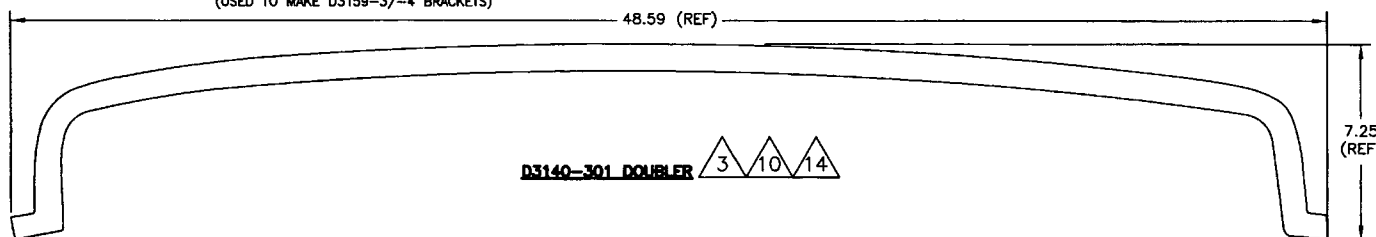
D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



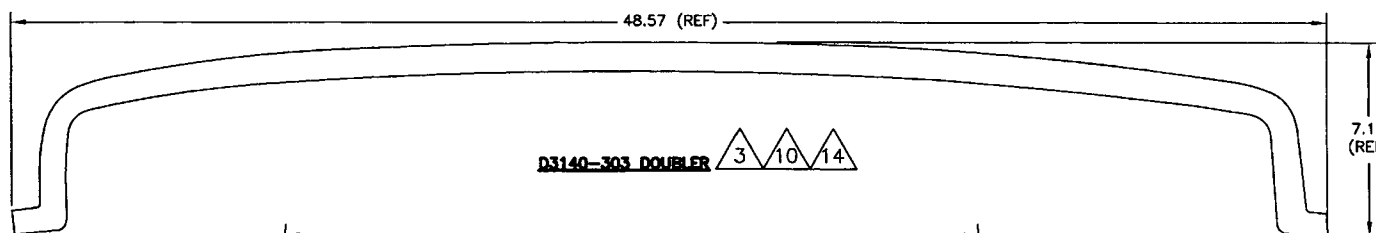
D3140-104 DOUBLER
D3140-103 OPPOSITE



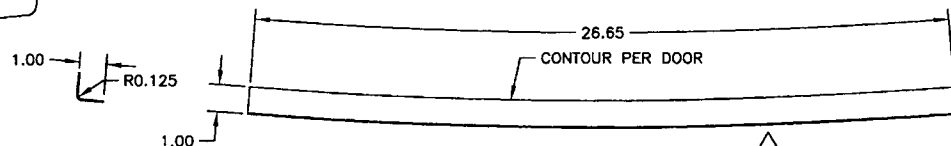
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER



D3140-303 DOUBLER



D3140-85 ANGLE
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N 830-23000-85)

RELEASED

06.11.13

COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. WARRICKS, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3140	REV. F	SHEET 6 OF 7	
DATE 06.10.06	TITLE DOOR	SCALE		NTS	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

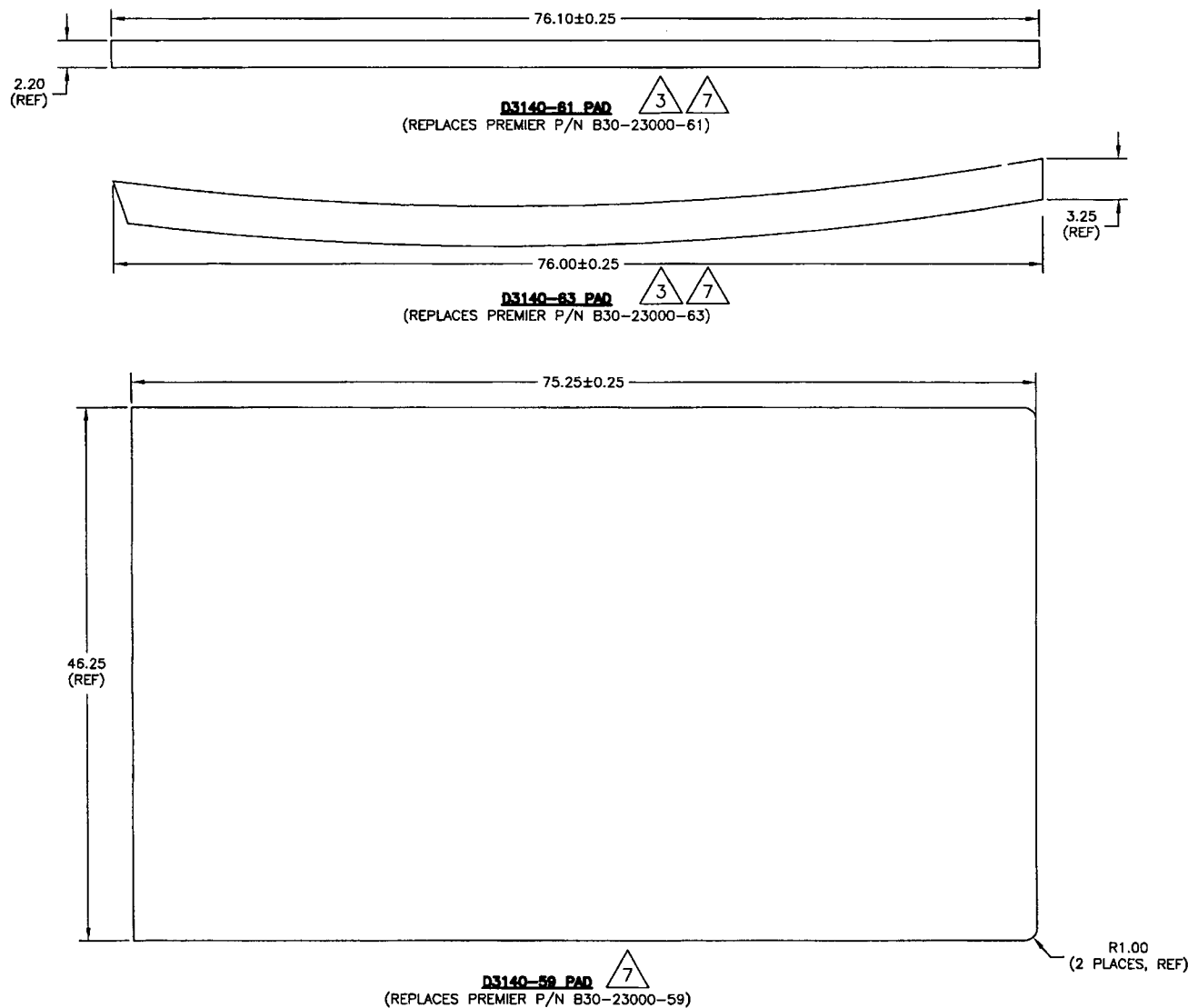
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78942



RELEASED
06.11.13

COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN #	DRAWN BY CB	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED JH	APPROVED	DRAWING NO. D3140	REV. F SHEET 7 OF 7
		DATE 06.10.06		TITLE DOOR	SCALE NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO16439**

Purchase Order Date 3/14/12

PO Print Date 4/23/12

Page Number 1 of 2

Order From :

VU-DEL003

DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

819 533 5788

819 533 3494

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3140-05P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50
		Special Inst: AS PER DWG D3140 REV. F B78940					
2	D3140-06P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50
		Special Inst: AS PER DWG D3140 REV. F B78941					
3	D3140-07P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50
		Special Inst: AS PER DWG D3140 REV. F B78942					
4	D3140-08P	DOOR	7/06/12 Yes	1.00 Each		\$8,062.5000	\$8,062.50

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr:

3

Change Date: 4/23/12



DELASTEK Inc.
2699 5e Avenue
Local 14, C.P. 10100
Grand-Mère, Québec G9T 5K7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	47283
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
07-03-2013	16-03-2012	20221	Chantal Lavoie	PO16439	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
Day & Ross Collect		Point de départ		Mathieu Doucet, ext.690	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC135-0017	Line #1 D3140-05 Door Left Non Assy (Grosse) U of M: Chaque B78940 DWG D3140 REV. F Serial # Lot # B78940. 40733	
1	0	1	DKC135-0018	Line #3 D3140-07 Door Left Non Assy (Petite) U of M: Chaque B78942 DWG D3140 REV. F Serial # Lot # B78942. 40733	

0360567

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request

Accepted by:

Quality department



AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Jeudi, 2012-04-26 14:13:57
Utilisateur: marc dubé

Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: DOOR KIT
Numéro Job	: 40733	Numéro Article	: DKC135-0017/-0018
Numéro Soumission	: 3406	Numéro Dessin	: D3140
Numéro B.A.	:	Projet Numéro	: DK-359
Cette fois	: 2012-04-26 No. B.V. :	Révision dessin	: F
Prsht Rev.	: NC	Matériel	: Fibercote E-761
Prem. fois	: - - Type :	Date Dûe	: 2012-07-02
Job précédente	: 40171	Qté:	1 Udm: UNITE
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Client: D3140-05/-07		

Process Sheet Rév.: 03 remplacer AAC0559 et AAC0563 par
AAC2032 et AAC1361 respectivement, changé AC0883 et AC0884
par AAC1885 et AAC1887 respectivement à 2 endroits qui avait
étés oubliés



DKC 135-0017

B 78940

DKC 135-0018

B 78942

Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description :

1.0

OUTILLAGE

Outillage nécessaire pour la job



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Moule N° B30-23000-01T

Patron de découpe N° B30-23000-57T

Patron de découpe N° B30-23000-61T

Patron de découpe N° B30-23000-63T

Patron de découpe N° B30-23000-71T

Patron de découpe N° B30-23000-73T

Patron de découpe N° B30-23000-75T

Patron de découpe N° B30-23000-77T

Patron de découpe N° B30-23000-79T

Gabarit de taillage N° B30-23000-05T (2 pièce) et N° B30-2300-03T

Forme de silicone N° B30-23000-07T

2.0

AAC0854

Frekote #700-NC

Commentaire Qty.: 0.030 UNITE(s)/Unit Total : 0.030 UNITE(s)

Frekote #700-NC

N° de Lot: 1-35027-1

3.0

PRÉPARATION

Préparation du moule



Commentaire Setup: 0.00Hrs/ Run: 130.0000Min Total Run : 2.1667Hrs

Faire la préparation du moule selon IF135-0001 et IG 0009

Utilisateur:

2012-04-20 14:10:37
marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD.

Nom Dessin: DOOR KIT

Numéro Job: 40733

Numéro Article: DKC135-0017-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

4.0

AMB0211

Epoxy prepreg E-761 style 7781

Commentair Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)

Epoxy prepreg E-761 style 7781

N° de Lot: 8-32611-8

5.0

DECOUPE

Découpe manuelle des pièces



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Découpe des tissus pré-impregné E-761 en paquet de 10.5 pi*. (7 Paquet = 24.5 verges)

Quantité: 1

Date: 23-08-12

Sceau:



6.0

* DRAPAGE

Drapage



Commentair Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs

Faire le drapage de 3 plis de tissus E-761 (4 Paquets) selon IF135-0001

Quantité: 1

Date: 24-08-12

Sceau:



7.0

AAC1885

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

Tissu à délaminer Release ply B

de Lot:

N/A

8.0

AAC1887

Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

Wrightlon 5200 Bleu P3

de Lot:

N/A

9.0

AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

10.0

AC0882

Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

11.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

12.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le bagging sur la pièce selon IF135-0001 et IG 0012

Quantité: 1

Date: 24-08-12

Sceau:



Utilisateur:

marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 40733

Numéro Article: DKC135-0017/-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

13.0

CUISSON

Cuisson de pièce



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièce selon IF135-0001, IG 0012 et PTN #20 N° de Cuisson: 7096Quantité: 1 Date: 28/08/12 Sceau: W/L

14.0

DÉMOULAGE

Démoulage de la pièce



Commentaire Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Retirer le montage cuisson et faire les retouches de la pièces afin d'enlever les surplus de résines et les résidus de tissu à délaminer.

Quantité: 1 Date: 30-08-12 Sceau: 

15.0

INSPECTION

Inspection générale



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: 1 Date: 31 août 12 Sceau: 

16.0

AAC1618

Rohacell 71S 1"thick 49.2" x 98.4" plain

Commentaire Qty.: 2.000 FEUILLE(s)/Unit Total : 2.000 FEUILLE(s)

Rohacell 71S 1"thick 49.2" x 98.4" plain

N° de Lot: 1-32097-1

17.0

DECOUPE

Découpe manuelle des pièces



Commentaire Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Faire la découpe des pièce de mousse structurales (Rohacell) sur la scie à ruban selon IF135-0001.

Quantité: 1 Date: 3/08/12 Sceau: S.V 4299

18.0

SÉCHAGE/ ANEAL

Séchage / Anealing



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le séchage du Rohacell selon IF135-0001 et les information du manufacturier. N° de Cuisson: 7074

Utilisateur:

marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 40733

Numéro Article: DKC135-0017/0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: 1

Date: 31/08/12

Sceau: 4299 S.V

19.0

AMB0442

Film adhésif de EA9696 36" large x 0.06 (psf)

Commentaire Qty.: 6.12 VERGE CAR(s)/Unit Total: 6.12 VERGE CAR(s)

Film adhésif de EA9696 36" large x 0.06 (psf)

20.0

AAC2032

Core splice adhesive NB-51/301

Commentaire Qty.: 5.0 PIED CARRE(s)/Unit Total: 5.0 PIED CARRE(s)

Core splice adhesive NB-51/301

N° de Lot: 1-36395-1

21.0

AAC1361

Putty AD Tech P-17

Commentaire Qty.: 0.50 UNITE(s)/Unit Total: 0.50 UNITE(s)

Putty AD Tech P-17

N° de Lot: 1-38354-2

22.0

AAC1630

N° D3140-09, Doubler

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-09, Doubler

N° de Lot: 1-37826-12

23.0

AAC1631

N° D3140-87, Doubler

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-87, Doubler

N° de Lot: 1-38371-1

24.0

AAC1632

N° D3140-91, Doubler

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-91, Doubler

N° de Lot: 1-37826-13

25.0

AAC1634

N° D3140-95, Doubler

Commentaire Qty.: 3 UNITE(s)/Unit Total: 3 UNITE(s)

N° D3140-95, Doubler

N° de Lot: 1-37826-8

26.0

AAC1635

N° D3140-97, Doubler

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-97, Doubler

N° de Lot: 1-37826-9

27.0

AAC1637

N° D3140-99, Doubler

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-99, Doubler

N° de Lot: 1-37826-14

28.0

AAC1638

N° D3140-101, Doubler

Commentaire Qty.: 2 UNITE(s)/Unit Total: 2 UNITE(s)

N° D3140-101, Doubler

N° de Lot: 1-37826-15

29.0

AAC1639

N° D3140-103, Doubler

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-103, Doubler

N° de Lot: 1-37826-16

30.0

AAC1641

N° D3140-105, Doubler

Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

N° D3140-105, Doubler

N° de Lot: 1-37826-17

Utilisateur:

marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 40733

Numéro Article: DKC135-0017/-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

31.0

AAC1643

N° D3140-241, Doubler

Commentaire Qty.: 1 UNITE(s)/Unit

Total : 1 UNITE(s)

N° D3140-241, Doubler

N° de Lot:

1-37826-21

32.0

AAC1644

N° D3140-301, Doubler

Commentaire Qty.: 2 UNITE(s)/Unit

Total : 2 UNITE(s)

N° D3140-301, Doubler

N° de Lot:

1-37826-18

1-37826-11

33.0

NETTOYAGE

Nettoyage des pièces



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le nettoyage des doublers selon IG 0063

Quantité: 1

Date: 24-10-12

Sceau:



T/c 209 - 248

34.0

ASSEMBLAGE

Assemblage mécanique



Commentaire Setup: 960.0Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Mise en place des doublers et des pièces de mousse structurales selon IF135-0001

Quantité: 1

Date: 25-10-12

Sceau:



35.0

AAC1885

Tissu à délaminer Release ply B

Commentaire Qty.: 4.37 VERGE(s)/Unit

Total : 4.37 VERGE(s)

36.0

AAC1887

Wrightlon 5200 Bleu P3

Commentaire Qty.: 7.18 VERGE(s)/Unit

Total : 7.18 VERGE(s)

37.0

AC0885

Feutre de drainage N° Airweave N 10

Commentaire Qty.: 6.00 VERGE(s)/Unit

Total : 6.00 VERGE(s)

38.0

AC0882

Sac à vide N° Stretchlon 700

Commentaire Qty.: 7.770 VERGE(s)/Unit

Total : 7.770 VERGE(s)

39.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentaire Qty.: 2.0000 ROULEAU(s)/Unit

Total : 2.0000 ROULEAU(s)

40.0

BAGGING

Faire le bagging sur la pièce



Commentaire Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0001 et IG 0012

Quantité: 1

Date: 26-10-12

Sceau:



T/c 209 - 248

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 40733

Numéro Article: DKC135-0017/0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

41.0

CUISSON

Cuisson de pièce



Commentaire Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièces selon IF135-0001, IG 0012, et PTN #20 N° de Cuisson: 7135Quantité: 1 Date: 26/10/12 Sceau:

42.0

DÉMOULAGE

Démoulage de la pièce



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson de sur la pièce et enlever les résidu de ruban adhésif en teflon et les barre d'aluminium, garder seulement la barre qui sépare les deux pièces.

Quantité: 1 Date: 29-10-12 Sceau:

43.0

DECOUPE

Découpe manuelle des pièces



Commentaire Setup: 0.00Hrs/ Run: 900.0000Min Total Run : 15.0000Hrs

Usinage des mousse structurales selon IF135-0001 et installer les doublets

Quantité: 1 Date: 27/11/12 Sceau:

44.0

INSPECTION

Inspection générale



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étapes.

Quantité: _____ Date: _____ Sceau: _____

 7 mars 2013
IV
Pas passer l'inspection

45.0 AMB0211

Epoxy prepreg E-761 style 7781

Commentaire Qty.: 12.30 VERGE(s)/Unit Total : 12.30 VERGE(s)

Epoxy prepreg E-761 style 7781 N° de Lot: 1-36396-1

46.0

DRAPAGE

Drapage



Commentaire Setup: 0.00Hrs/ Run: 12.0000Hrs Total Run : 12.0000Hrs

Drapage de la coquille intérieur selon IF135-0001

Quantité: 1 Date: 18/01/2013 Sceau:

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 40733

Numéro Article: DKC135-0017/-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

47.0

AAC1885

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)

48.0

AAC1887

Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)

49.0

AC0885

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)

50.0

AC0882

Sac à vide N° Stretchlon 700

Commentair Qty.: 7.770 VERGE(s)/Unit Total : 7.770 VERGE(s)

51.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 ROULEAU(s)/Unit Total : 2.0000 ROULEAU(s)

52.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le montage cuisson selon IF135-0001 et IG 0012.

Quantité: 1 Date: 18-01-13 Sceau:



53.0

CUISSON

Cuisson de pièce



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la cuisson de la pièces selon IF135-0001, IG 0012, et PTN #20 N° de Cuisson: 7313

Quantité: 1 Date: 19-01-13 Sceau:

54.0

DÉMOULAGE

Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Retirer le montage cuisson et faire des retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer

Retirer la pièce du moule

Quantité: 1 Date: 20-1-2013 Sceau:



55.0

INSPECTION

Inspection générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel"

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: DOOR KIT

Numéro Job: 40733

Numéro Article: DKC135-0017-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: _____ Date: _____ Sceau: _____

56.0

TRIMAGE

Trimage



Commentaire Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs

Faire le trimage de finition de la pièce selon IF135-0003

Quantité: 1 Date: 20/02/13 Sceau: 

Inspection 56.1
21 Jan 2013
IV

57.0

AAC1021

Dupont Primer N° 7704S

Commentaire Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-36423-1

58.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentaire Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-38821-1

59.0

PRIMER

Application primer



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

2^e partie Quantité: 2/1/13 Date: 1 Sceau:  N° Fiche mélange: N/A

première partie: 19-02-13



60.0


SABLAGE

Sablage



Commentaire Setup: 0.00Hrs/ Run: 240.0000Min Total Run : 4.0000Hrs

Faire le sablage du primer selon IF135-0003

Quantité: 1 Date: 22/02/13 Sceau: 



61.0

PRIMER

Application primer



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

Faire l'application du primer selon IG 0008.

1^{ère} partie Quantité: 1 Date: 21/02 Sceau:  N° Fiche mélange: N/A



Date: 2012-04-26 14:13:57
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD
Numéro Job: 40733

Nom Dessin: DOOR KIT
Numéro Article: DKC135-0017/-0018

Numéro Job:



Séq.:

Machine ou Opération:

Description :

62.0

IDENTIFICATION

Identification des pièces



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'identification des pièces sur l'aluminium peinturé dans le dégagement des mécanisme de porte selon IG 0055.

N° de pièce Grosse porte: D3140-05

N° de pièce Petite porte: D3140-07

N° de Job (sur les 2 pièces): 40733

Date de fabrication (sur les 2 pièces): MAR 1 2013

Sceau d'inspection.

Quantité: 1

Date: 1-03-13

Sceau: DELASTEK 6

63.0

INSPEC FINAL

Inspection finale



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire l'inspection finale des pièces par le département de la qualité selon le dessin D3140.

Quantité: 1

Date: 6 mars 13

Sceau: DELASTEK GA-3

64.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Emballer et entreposer selon IG 0057

Quantité: 1

Date: 6 mars 13

Sceau: DELASTEK 53

Fab: 1^{er} mars 2013